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D2432-3

Job Sheet 206154



Part No: D2432-3

Job Qty: 4 pcs

Part Name: 206 (24") Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/27/20

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP REV:A AS PER REV G 12-07-24 JLM VERIFIED BY:DD IPP REV:B 12.10.17 AS PER DWG
REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	4 pcs	2/14/20	2/14/20	0.17	0.96	Waterjet - Omax		on 20/02/11
130	HAAS 4 Axis - B4B	4 pcs	2/14/20	2/14/20	1.00	6.57	HAAS - 1 - B4B		20/02/11
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	4 pcs	2/14/20	2/14/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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QC 2 - 63			
QC 2 - 66			
QC 2 - 64			
QC 2 - 65			
QC 2 - 5			
QC 2 - 71			
QC 2 - 73			
QC 2 - 69			
QC 2 - 76			
QC 8 - 12	0.00 0.00	2/14/20	4 pcs
QC 8 - 14			
QC 8 - 17			
QC 8 - 20			
QC 8 - 25			
QC 8 - 3			
QC 8 - 32			
QC 8 - 33			
QC 8 - 35			
QC 8 - 39			
QC 8 - 4			
QC 8 - 44			
QC 8 - 45			
QC 8 - 49			
QC 8 - 58			
QC 8 - 8			
QC 8 - 9			
QC 8 - 68			
QC 8 - 67			
QC 8 - 1 (A)			
QC 8 - 47			
QC 8 - 40			
QC 8 - 52			
QC 8 - 23			
QC 8 - 57			
QC 8 - 76			
QC 8 - 61			
Packaging 3 - 1 - B4B	0.00 0.00	2/14/20	160 Packaging 3-1 - Stock - B4B 4 pcs
Packaging 3 - 2 - B4B			
Packaging 3 - 3 - B4B			
Packaging 3 - 4 - B4B			
Packaging 3 - 5 - B4B			
Packaging 3 - 6 - B4B			
Packaging 3 - 7 - B4B			
Packaging 3 - 8 - B4B			
Packaging 3 - 9 - B4B			
Packaging 3 - 10 - B4B			
Packaging 3 - 11 - B4B			
Packaging 3 - 12 - B4B			
Packaging 3 - 13 - B4B			
Packaging 3 - 14 - B4B			
Packaging 3 - 15 - B4B			
Packaging 3 - 16 - B4B			
Packaging 3 - 17 - B4B			
Packaging 3 - 18 - B4B			
Packaging 3 - 19 - B4B			
Packaging 3 - 20 - B4B			
Packaging 3 - 21 - B4B			
Packaging 3 - 22 - B4B			
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FEB 25 2020

9-89 80 97463

DAS

20/2/19

OK 20/02/25

Part Op 120 - (Waterjet 2) Cut Blank as per D2432 File
 Descriptions: 130 - (HAAS CNC vertical machine #1) 1-inspect material for defects or damage prior to machining 2-Machine as per Folio B122 and Dwg D2432 identify as D2432-3
 140 - (QC2- inspect parts off machine FAL/FAIB)
 150 - (QC8- inspect parts - second check)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Part / Item	Component Name	Quantity	Operation	Container
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Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black x120" Tivar Mfg.#52480104	14,8000 sf (3.7 ea)	120-Waterjet - Omax - 1	5235828

Operation	Component Part	Required	Inventory	Allocated
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Operation	120-Waterjet - Omax - 1	MUHMMWB10	Required	15	Inventory	478	Allocated	0
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Specifications could not be found.

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Rev	A	Date	16.06.23	Change	New Issue	Revised by	KJ	Approved	M
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Engineering Approval:	(if necessary)	Date:
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Measured by:	DAS	Checked by:	9/7	Date:	20/02/25	QC Inspector:	Date:
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Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 260	+0.006/-0.001	0.260	/		Vernier	CNC-019
B	0.93	+/-0.030	0.919	/		"	
C	0.300	+0.030/-0.000	0.310	/		Depth Gauge	JB5-04
D	0.06 x 45°	+/-0.030 x +/-0.5°	0.06 x 45°	/		Vernier	CNC-019
E	2.000	+/-0.010	2.010	/		"	
F	11.000	+/-0.010	11.010	/		"	
G	20.000	+/-0.010	20.010	/		"	
H	4.250	+/-0.005	4.255	/		Calculated	
I	5.50	+/-0.030	5.500	/		Calculated	
J	19.00	+/-0.030	19.000	/		Calculated	
K	23.75	+/-0.030	23.750	/		M-Tape	
L	0.25 x 45°	+/-0.030 x +/-0.5°	0.25 x 45°	/		"	
M	0.95	+/-0.030	0.947	/		Vernier	CNC-019
N	0.63	+/-0.030	0.640	/		"	
O	0.250	+/-0.010	0.255	/		"	
P	0.380	+0.030/-0.010	0.385	/		Deep Micrometer	
Q	1.4	+/-0.030	1.4	/		Calculated	
R	0.38	+/-0.030	0.383	/		Vernier	
S	R0.25	+/-0.030	0.25	/		Calc	
T							
U							
V							
W							
X							
Y							
Z							
AA							
AB							

INSPECTION SHEET

Work Order:	206154
Part Number:	D2432-3
Description:	206 Bearpaw
Inspection Dwg:	D2432
Rev:	H
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Entered: _____ Date: _____

NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: _____		DISPOSITION		DEPARTMENT/PROCESS					
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec./Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		Disposition		MRB (QS1042)			
Description Work Order Deviation				Disposition		Completed By			
						Lead hand / Supervisor			
						QC / QA Coordinator			
Root Cause				FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Other/Details: _____									